

Date: Thursday, 18/12/2008 12:51:52 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER			
Job Number	: 44177						
Estimate Number	: 13066						
P.O. Number	:			Part Number	: D36811		
This Issue	: 18/12/2008	S.O. No. :		Drawing Number	: D3681 REV A		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: 18/12/2008	Type :	MACHINED PARTS	Drawing Revision	: A		
Previous Run	: 41248			Material	:		
Written By	:			Due Date	: 23/12/2008		
Checked & Approved By	: <u>JD 08.12.19</u>			Qty:	40	Um: Each	
Comment	: Est Rev A new issue 07-10-30 DD verified by: Est Rev:B Ecn 1056 Rev A dwg DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T03125W058	ALUM TUBE .3125 x .058w	
		Comment: Qty.: 0.3570 f(s)/Unit Total : 14.2800 f(s) Material: (M6061T6T0.313W.058) Batch: <u>1109240</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: 1-TURN AS PER FOLIO FA711& DWG D3681 FOLIO REV: <u>A</u> DWG REV: <u>A</u>	
		2-DEBURR AS REQUIRED	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Barkley</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 44177

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44177
Description: Spacer	Part Number:	D3681-1
Inspection Dwg: D3681	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

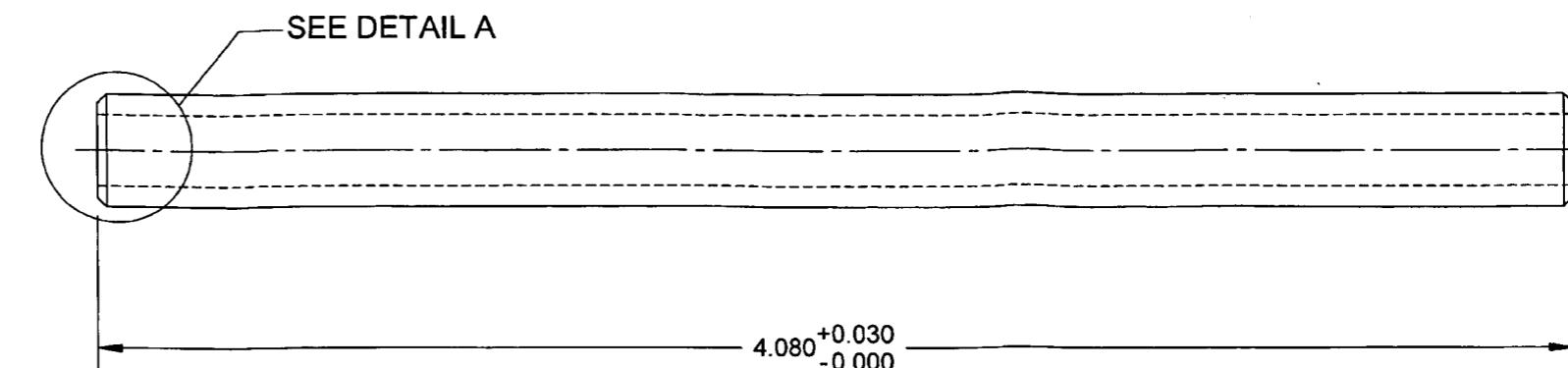
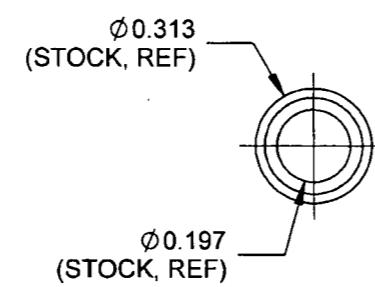
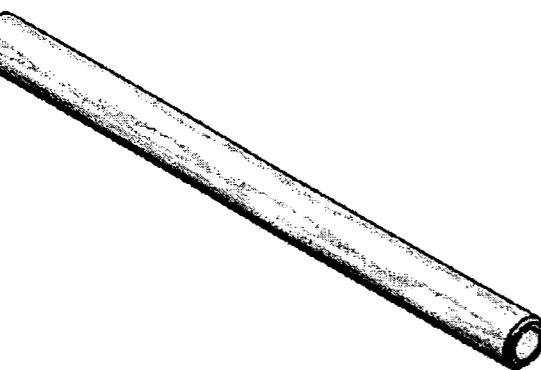
X First Article Prototype

Measured by:	<i>Amf</i>	Audited by:	<i>Amf</i>	Prototype Approval:	N/A
Date:	08/12/20	Date:	05/12/23	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	08.01.16	New Issue	KJ/EC/DD	MM

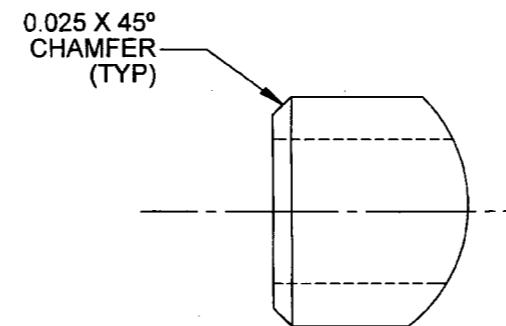
8 7 6 5 4 3 2 1

D



D3681-1 SPACER

B



DETAIL A
(SCALE 4 : 1)

RELEASED
07-11-08

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 44177

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

C

B

A

A

A	NEW ISSUE	DC	07.11.08
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	RE	DRAWING NO.	
MFG. APPR.	ED	REV. A	
APPROVED	MM	D3681	SHEET 1 OF 1
DE APPR.	MM	TITLE	
DATE	07.11.08	SCALE	
		SPACER	2:1

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8 7 6 5 4 3 2 1